Work Order ID 7. Monday, September 12, 201					AS	MO	Pag
Item ID: D3340-7 Revision ID: Item Name: Fwd Skidtub Start Date: 9/12/2011 Required Date: 9/14/2011 Reference:	Start Qty: 4.00 Req'd Qty: 4.00		Accept	Cust Item ID: Customer:		Setup Start	
Approvals: Process P QC:	lan: MC	Date: \\-\09-12 Date:	Tooling: SPC (Y/N):	Date:		Run Star Stop	! ! !!! !!! ! ! !!!!! ! !! !!!!!
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Accept Code Qty		Reject Insp. Number Stamp
	evision Nbr		Run Hours	,	Code Qty	Qty	Number Stamp
D3340 Re	ev B			j			
Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as per Deburr if nec	Dwg D3340 É⊒Dwg Rev: essary	0.00 . 0.00 2 □Prog Rev: <u>R</u>	<u>. </u>	<u> </u>	-9-13	5
110	QC2- Inspect parts off ma	achine FAI/FAIB	0.00		,		
QC Quality Control	Memo		سسدمير 0.00		HB	11-9-13	
120 QC	QC8- Inspect parts - seco	nd check	0.00 Sulval	゚゚゚゚	ES		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approvai Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #: Fault Category: N	CR: Ye	s No DQ	A:	Date: _	

	Re	solution:	Dispositio	n: (A: N/C Clo	sed:	Date: _	
NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

Page 2

Insp.

Stamp

Work Order ID 73663 Monday, September 12, 2011 10:14:16 AM Item ID: D3340-7 Accept Setup Start Revision ID: Stop Fwd Skidtube Protector Item Name: Start Date: 9/12/2011 Start Otv: 4.00 **Cust Item ID:** Required Date: 9/14/2011 Req'd Qty: 4.00 **Customer:** Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description **Run Hours** Code Qty Qty Number 130 0.00 NC BRAKE (\mathcal{L}) Brake NC 0.00 Deburr if necessary DForm on brake as per Dwg D3340 using Jigs DT 33 Brake NC and DT 8261 140 QC5- Inspect part completeness to step on W/O QC 0.00 Memo Quality Control 150 Grey Sandtex(Ref: 4.3.5.6) per QSI005 4.3 0.00 Powdercoat Memo

Powder Coating W 117 334 START TIME: _□FINISH TIME:

COVEN TEMPERATURE:

5x & mf Wod/14

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W/O:			WO	RK ORDER CHANG	ES	•			
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Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	₹)			,
DATE	STEP	Description of NC		Corrective Action Secti		Verific	ation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign o		on C	Chief Eng	QC Inspector
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Page 3

Insp.

Monday, September 12, 2011 10:14:16 AM Item ID: D3340-7 Accept Setup Start **Revision ID:** Stop Fwd Skidtube Protector Item Name: Start Qty: 4.00 **Start Date:** 9/12/2011 **Cust Item ID:** Required Date: 9/14/2011 Req'd Qty: 4.00 **Customer:** Reference: Run Start Process Plan: Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Reject Accept Reject **Work Center ID** Description Qty Qty **Run Hours** Code Number Stamp 160 QC3- Inspect Part Finish 0.00 QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 170 0.00 Packaging 0.00 Memo Packaging

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	n:	QA: N/C C	losed:	· · · · · · · · · · · · · · · · · · ·	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign		cation		Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector
	1								

Picklist Print

Monday, September 12, 2011 10:14:14 AM

Work Order ID: 73663

Parent Item: D3340-7

Parent Item Name: Fwd Skidtube Protector



Start Date: 9/12/2011

Required Date: 9/14/2011

1811-9-13

Start Qty: 4.00

Required Qty: 4.00

Page 1

Comments:

IPP: A 05.11.10 Preliminary issue

AP/EC

IPP Rev:B Now on Waterjet 06-09-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No		100	sf	150.5000	0.889	3.743158	4.4		

1010/1025 SHEET

Location	Loc Qty	Loc Code
MAT019	150.5	
111410	64	
116791	86.5	

Dart Aerospace Ltd

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W/O:		WORK ORDER CH	IANGES				·
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No): 	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORD	ER NON-CONFORMANC	CE (NCR)			
		Description of NC		Corrective Action Section B	,	Verification	Annroyal	Annroyal
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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DART AEROSPACE LTD	Work Order:	73665
Description: Fwd Skidtube Protector	Part Number:	D3340-7
Inspection Dwg: D3340 Rev: B		Page 1 of 1

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FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250 x 0.300	+/-0.010	->59x36	, Z		VBOL	
0.50	+/-0.030	,498	9		V	
0.250	+/-0.010	248	ъ		V	
1.625	+/-0.010	1.636	7		V	
2.815	+/-0.010	2.811	4		V	
2.315	+/-0.010	2.311	7		V	
1.815	+/-0.010	1,813	7		V	
22.780	+/-0.010	25.780 '	\		7 1301	
26.280	+/-0.010	26.286	>		7	
34.655	+/-0.010	34,65	l		7	
38.155	+/-0.010	0	×		7	
40.355	+/-0.010	40.358			न ।	
43.855	+/-0.010	43.85	4		T	
45.730	+/-0.010	45.730	Э		7	
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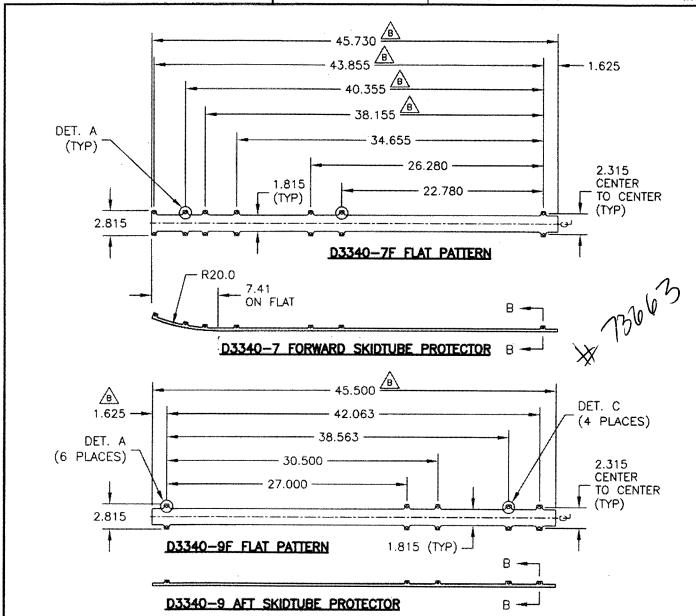
Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-9-13	Date: (1/08/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.11.23	New Issue	KJ/EC/DD/	
				-

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** DATE STEP **PROCEDURE CHANGE** By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ___ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng



DESIGN MB	DRAWN BY MB	DA	RT AEROSPACI HAWKESBURY, ONTARIO, CA		
CHECKED A	APPROVED	DRAWING NO.		***************************************	REV. B
at	1 #	D3340		SHEET	4 OF 11
DATE		TITLE		***************************************	SCALE
05.11.22		SKIDTUBE	PROTECTOR		1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX



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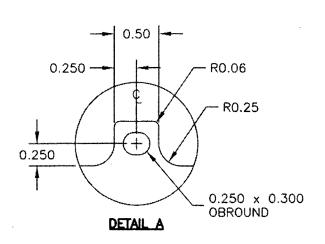
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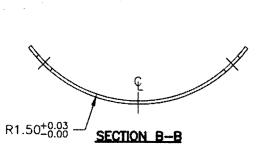
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W/O:			W	ORK ORDER CHANGE	ES					5
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			 							
Part No	:	PAR #:	Fault Cat	egory:	NCR: Y	es N	lo DQ A	\:	Date:	
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Si	gn & Oate	Verific Section		Approval Chief Eng	Approval QC Inspector
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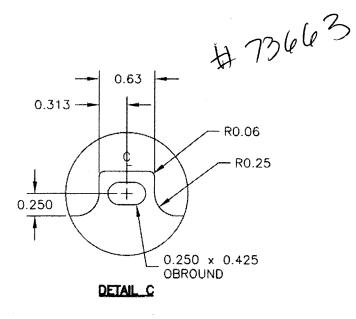
NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
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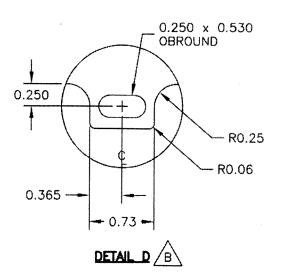


DESIGN MB	DRAWN BY MB	DA	ART AEROSPA HAWKESBURY, ONTARIO,	
CHECKED (M	APPROVED .	DRAWING NO.		REV. 8
#	1	D3340		SHEET 11 OF 11
DATE		TITLE		SCALE
05.11.22		SKIDTUBE	PROTECTOR	1:1









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W/O:		WORK ORDER CHANGES			-		•
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Resolution:		Disposition:	QA: N/C Closed	:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B			Verification	Verification Approval	Approval	
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